

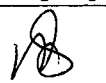

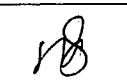
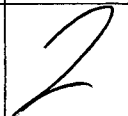
5/15/16


(4)

DART AEROSPACE LTD	Work Order:	22409
Description: Mounting Lug/Nut Plate Kit	Part Number:	K10017
Dwg: D3175 Rev. A; D3178 Rev. A	Qty:	4 8
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Note: K10017 Kits to be made in multiples of 4. (1) K10017 Kit consists of (2) D3175-041 and (2) D3178-041.	HA	05.02.14	8
2	MV	Cut blanks: 3.00" x 1.520" Material: 5052-H32/H34 sheet (QQ-A-250/8) 0.063" thick (M5052H32S.063) (Cut 1 stack of 8 per (4) K10017) Identify as D3178-1 Batch: M15628	En	05/08/2016	16
3	MV	Cut blanks: 2.5" x 1.5" x 2.2" (grain along 2.2") Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-250/11) (M6061T6B1.500x02.500) (Cut 16 blanks per (4) K10017) Identify as D3175-1 Batch: M167482 (Note: (2) D3175-1 are required per D3175-041 assembly)	En	05/08/2016	32
4	MV	Cut blanks: 2.125" x 1.250" Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-250/11) 0.375" thick (M6061T6B0.375x01.250) (Cut 8 blanks per (4) K10017) Identify as D3175-3 Batch: M17807	En	05/11/13	16
5	MV	Machine D3178-1 as per Folio FA296 and Dwg D3178	En	05/11/14	16
6	QC2	Inspect parts as they come off the CNC machine	En	05/11/14	16
7	QC8	Second inspection	JL	05.11.14	16
8	MV	Machine D3175-1 as per Folio FA293 and Dwg D3175	SA/En	05.11.15	43
9	QC2	Inspect parts as they come off the CNC machine	SA/En	05.11.15	43
10	MV	Deburr and Tumble	SA/En	05.11.15	43
11	QC8	Second inspection	BL	05.11.16	43
12	MV	Machine D3175-3 as per Folio FA294 and Dwg D3175	SA	05.11.16	16
13	QC2	Inspect parts as they come off the CNC machine	SA	05.11.16	16
14	MV	Deburr and Tumble	SA	05.11.16	16
15	QC8	Second inspection	BL	05.11.16	16
16	GA	C'sink D3178-1 holes as per Dwg D3178	SA	05/11/17	16
17	GA	Deburr stack of D3178-1	SA	05/11/17	16
18	QC5	Inspect C'sink	SA	05-11-17	16
19	FP	Chemical Conversion Coat D3178-1, D3175-1 & D3175-3 per QSI 005 4.1	SA	05/11/19	16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/11/14	# 8	1) one part scrap D375-1 origin was d.f. by 0.040" to small.	 05/11/14	Scrap, destroy and Repture. fix origin so it never happen again	En 05/11/17	 05-11-17	 05/11/17	 05-11-15

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 05-12-2014

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	22409
Description: Mounting Lug/Nut Plate Kit	Part Number:	K10017
Dwg: D3175 Rev. A; D3178 Rev. A	Qty:	1
Page 2 of 2		

Step	Location	Procedure	By	Date	Qty																
20	QC3	Inspect Conversion Coat	SB	05/11/22	8																
21	GA	Assemble D3178-041 as per Dwg D3178 Pick: <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>16</td><td>MS20426AD3-4</td><td>Rivet</td><td>M15786</td></tr><tr><td>8</td><td>MS21059L3</td><td>Nut Plate</td><td>M12240</td></tr></table> <div>(12) M12240 2</div> Identify as D3178-041	Qty	Part Number	Description	Batch	16	MS20426AD3-4	Rivet	M15786	8	MS21059L3	Nut Plate	M12240	SB	05/11/22	8				
Qty	Part Number	Description	Batch																		
16	MS20426AD3-4	Rivet	M15786																		
8	MS21059L3	Nut Plate	M12240																		
22	QC5	Inspect D3178-041 Assembly	2	05-11-28	8																
23	GA	Assemble D3175-041 as per Dwg D3175 Pick: <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>4</td><td>AN3-7A</td><td>Bolt</td><td>M5288</td></tr><tr><td>8</td><td>AN960JD10L</td><td>Washer</td><td>M18235</td></tr><tr><td>4</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M17652</td></tr></table> Identify as D3175-041	Qty	Part Number	Description	Batch	4	AN3-7A	Bolt	M5288	8	AN960JD10L	Washer	M18235	4	MS21042L3	Nut (or -3)	M17652	SB	05/11/22	8
Qty	Part Number	Description	Batch																		
4	AN3-7A	Bolt	M5288																		
8	AN960JD10L	Washer	M18235																		
4	MS21042L3	Nut (or -3)	M17652																		
24	QC5	Inspect D3175-041 Assembly	2	05-11-28	8																
25	FP	Powder Coat D3175-041 Only Gloss White (Ref: 4.3.5.1) per QSI 005 4.3	FE	05/12/07	8																
26	QC3	Inspect Powder Coat	MM	05/12/07	8																
27	PK	Identify and Stock as K10017. Note: (1) Kit consists of (2) D3175-041 and (2) D3178-041. <table><tr><td>Part Number</td><td>Description</td><td>Qty</td></tr><tr><td>D3175-041</td><td>Mounting Lug</td><td>16</td></tr><tr><td>D3178-041</td><td>Nut Plate</td><td>16</td></tr></table> <div>ID + stock</div>	Part Number	Description	Qty	D3175-041	Mounting Lug	16	D3178-041	Nut Plate	16	16	05/12/07	16							
Part Number	Description	Qty																			
D3175-041	Mounting Lug	16																			
D3178-041	Nut Plate	16																			
28	AC	Parts to stock and Prorate cost to parts per Step 27. Cost / part	4	05/12/06	16																
29	DC	Close W/O Inspect Level 21	9	05/12/06	16																

Rev	Date	Change	Revised By	Approved
A	03.01.28	New issue	KJ/RF	
B	03.02.28	Modify Step 1,2,3,4,21,23	KJ/RF	

RELEASED
03.02.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05/11/28	23	11x D 3175-1 brackets left over. Identify and stock 6003402	CL	05/11/28	11	U 05.11.28	 05-11-28

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

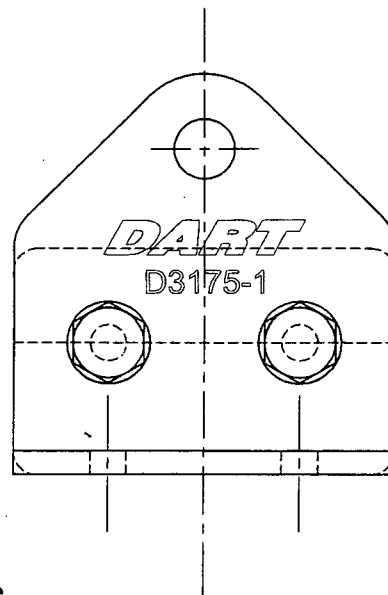
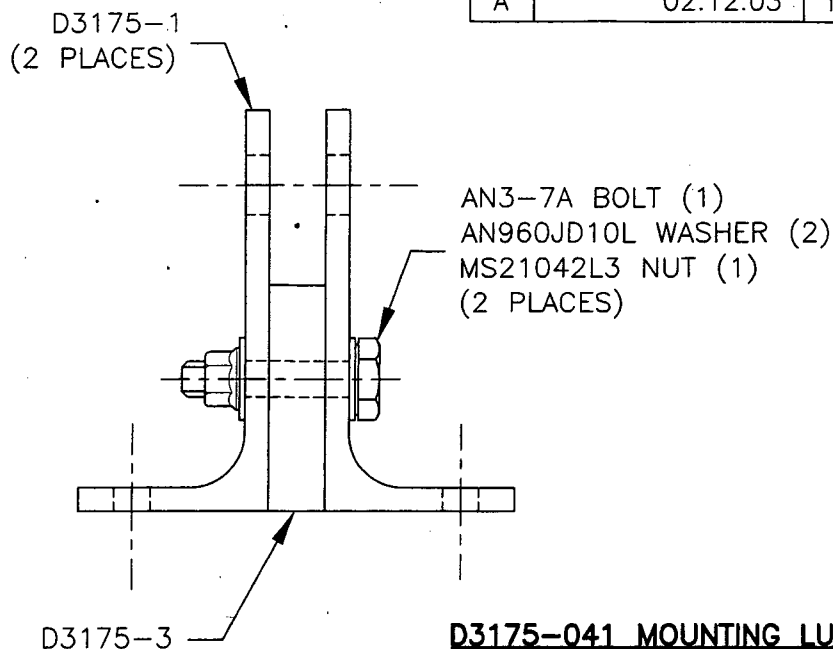
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Date: 05/12/20

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



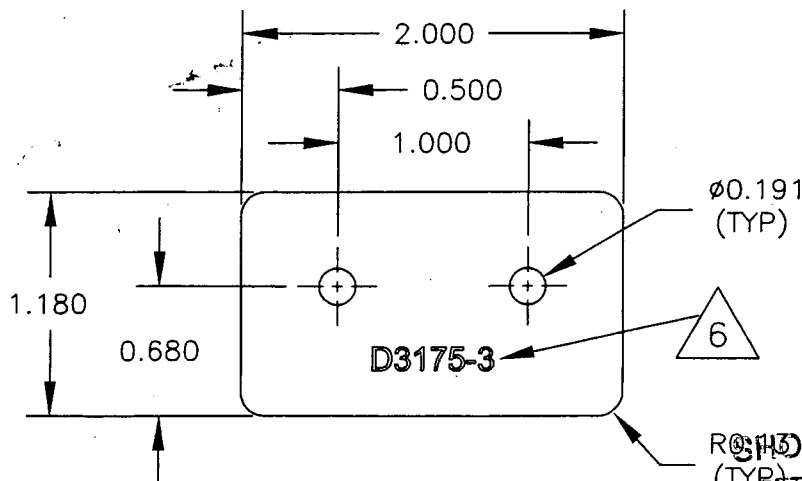
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3175	REV. A SHEET 1 OF 2
DATE 02.12.03		TITLE MOUNTING LUG	SCALE 1:1
A	02.12.03	NEW ISSUE	



D3175-041 MOUNTING LUG

FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1)
PER DART QSI 005 4.3

RELEASED
02.12.03 #



D3175-3 SPACER

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.285 TO 0.290 THICK
(QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE P/N IN THIS AREA AS SHOWN TO A DEPTH OF 0.010 MAX

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WORK ORDER
NO. 22409

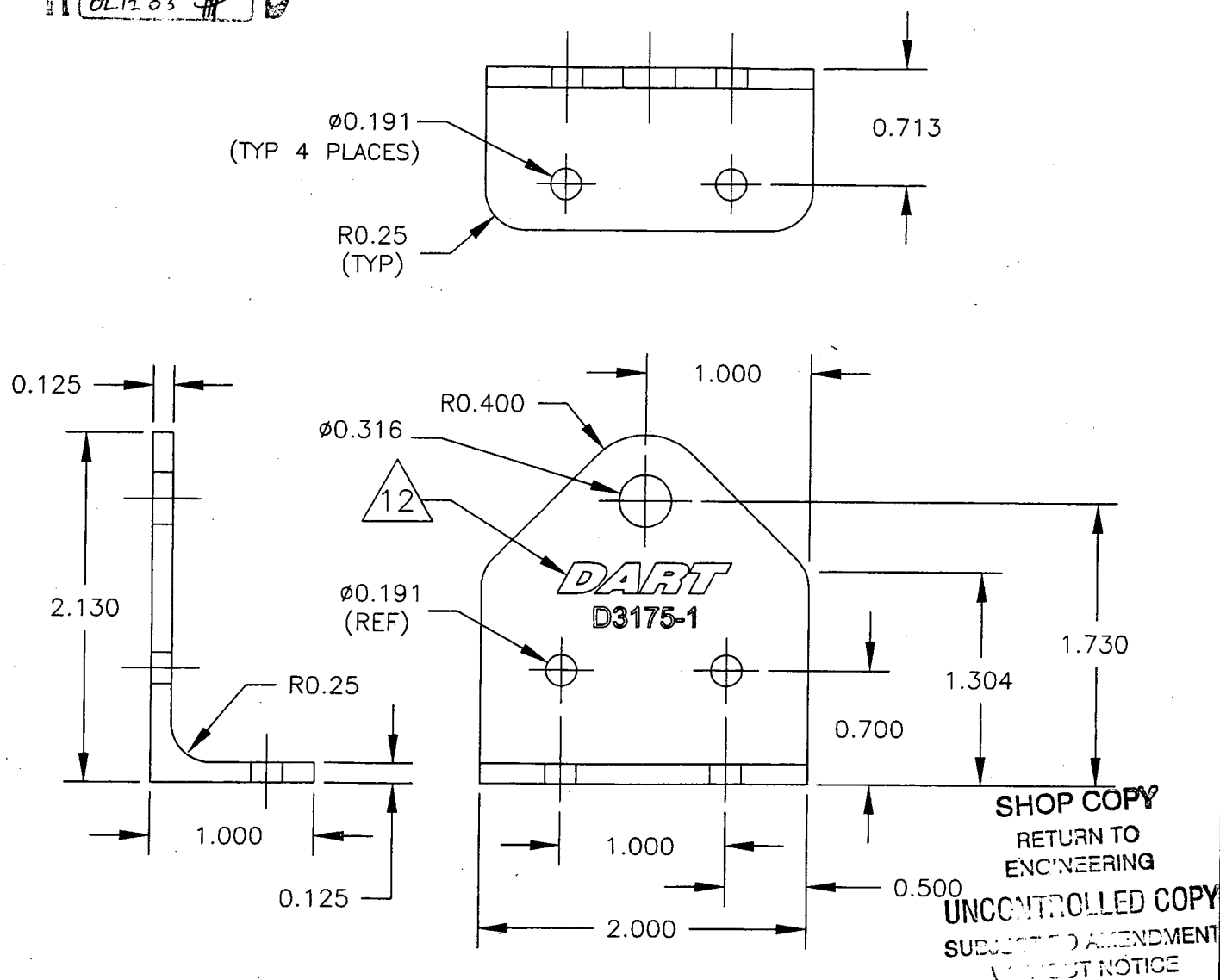
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CHECKED <i>##</i>	APPROVED <i>##</i>	DRAWING NO. D3175	REV. A SHEET 2 OF 2
DATE 02.12.03		TITLE MOUNTING LUG*	SCALE 1:1

RELEASED
OL 12 03



D3175-1 BRACKET

- 7) MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 9) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) ENGRAVE DART LOGO & P/N IN THIS AREA AS SHOWN TO A DEPTH OF 0.010 MAX

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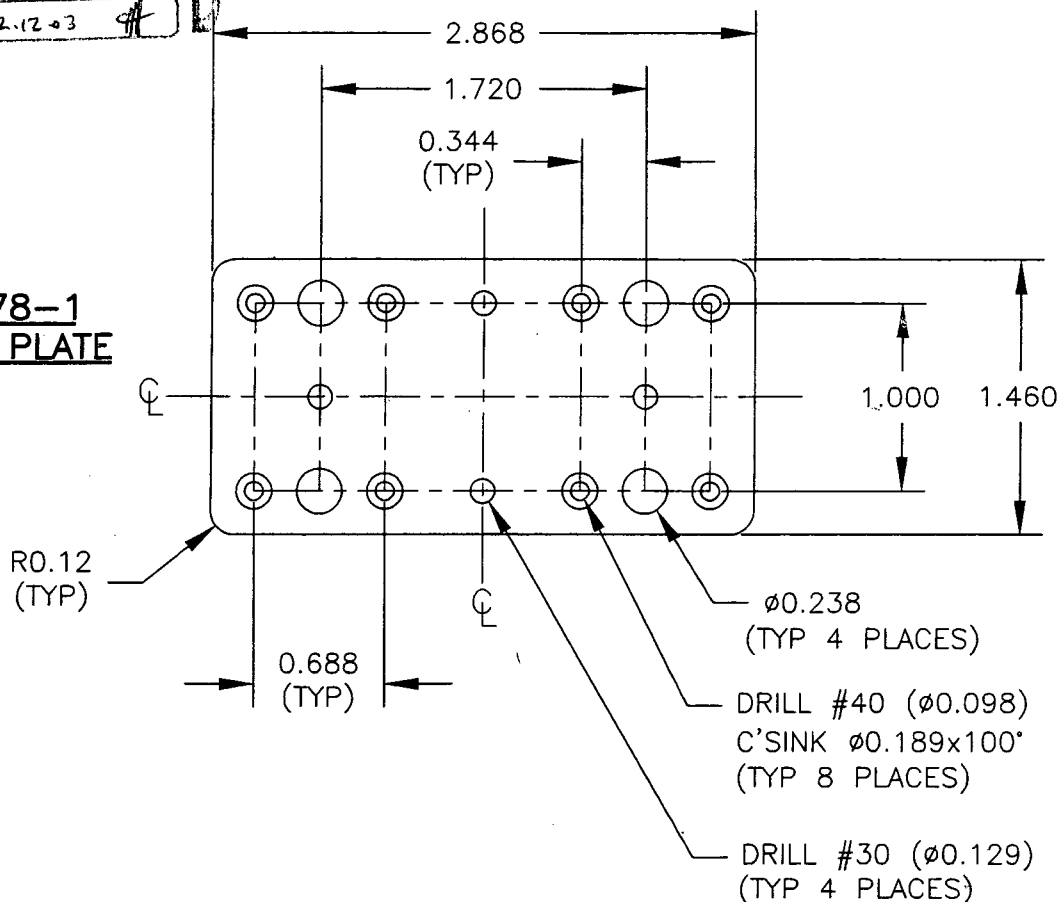
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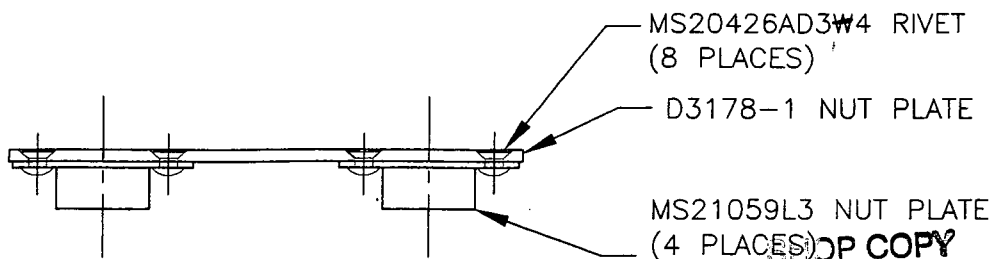
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3178	REV. A SHEET 1 OF 1
DATE 02.12.03		TITLE NUT PLATE	SCALE 1:1
A	02.12.03	NEW ISSUE	

RELEASED
02.12.03 *[Signature]*

**D3178-1
NUT PLATE**



**D3178-041
NUT PLATE**



NOTES. D3178-1 NUT PLATE:

- 1) PART IS SYMMETRIC ABOUT CENTERLINES
- 2) MATERIAL: 5052-H32/H34 SHEET 0.063 THICK (QQ-A-250/8)
(REF DART SPEC. M5052H32S.063)
- 3) BREAK ALL SHARP EDGES 0.005-0.010
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE

WORK ORDER
NO. 22409

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 14, 2005
07:34 am

Work Order No : 0022409
Project Name : K10017
Project For : WK515
Work Order Type : Main
Main WO Number :
House Part Number : *K10017
Description : Mtg Lug/Nut Plate Kit
Manufactured : Yes
Amount Req'd : 1
Amount Done : 0
Start Date : 02-11-05
Est Finish Date : 02-24-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:12 am

Work Order No : 0022409
Project Name : K10017
Project For : WK515
Work Order Type : Main
Main WO Number :
House Part Number : *K10017
Description : Mtg Lug/Nut Plate Kit
Manufactured : Yes
Amount Req'd : 1
Amount Done : 0
Start Date : 02-11-05
Est Finish Date : 02-24-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
=====					
Burden :	0.00	0.00	0.00		
=====					
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Date: Tuesday, 11/22/2005 7:51:17 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MOUNTING LUG/NUT PLATE KIT
Job Number :	22409		
Estimate Number :	10830		
P.O. Number :		Part Number :	K10017
This Issue :	11/22/2005	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	N/A
First Issue :	//	Project Number :	
Previous Run :	22409	Drawing Revision :	N/A
Written By :		Material :	
Checked & Approved By :		Due Date :	11/29/2005
Comment :	Est: B 03.02.28 Modify Step 1,2,3,4,21,23 KJ/RF		

Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	22409A	MOUNTING LUG
-----	--------	--------------



Comment: Sub-Component MOUNTING LUG

2.0	22409B	NUT PLATE ASSEMBLY
-----	--------	--------------------



Comment: Sub-Component NUT PLATE ASSEMBLY

3.0	22409C	MOUNTING LUG ASSEMBLY
-----	--------	-----------------------



Comment: Sub-Component MOUNTING LUG ASSEMBLY

4.0	D3175041	Mounting Lug
-----	----------	--------------

5.0	D3178041	Nut Plate
-----	----------	-----------

6.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
-----	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

7.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

8.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL
 Inspection Level 21

Job Completion



Date: Tuesday, 11/22/2005 7:52:24 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MOUNTING LUG
Job Number :	22409A		
Estimate Number :	10817		
P.O. Number :		Part Number :	D31753
This Issue :	11/22/2005	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3175 REV. A
First Issue :	/ /	Project Number :	
Previous Run :	22409B	Drawing Revision :	A
	Type :	Material :	
	SMALL /MED FAB	Due Date :	11/29/2005
Written By :		Qty:	2
Checked & Approved By :		Um:	Each
Comment :	Est:B 03.02.28 Modify Step 1,2,3,4,21,23 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0375X01250	6061-T6 Bar .375 x 1.25"
-----	--------------------	--------------------------

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks: 2.125" x 1.250"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA294 and Dwg D3175

Deburr and Tumble

Identify as D3175-3

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Date: Tuesday, 11/22/2005 7:52:24 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 22409A

Part Number: D31753

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Date: Tuesday, 11/22/2005 7:52:29 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	NUT PLATE ASSEMBLY
Job Number :	22409B		
Estimate Number :	10812		
P.O. Number :		Part Number :	D3178041
This Issue :	11/22/2005	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3178 REV. A
First Issue :	//	Project Number :	
Previous Run :	22409C	Drawing Revision :	A
	Type :	Material :	
	SMALL /MED FAB	Due Date :	11/29/2005
Written By :		Qty:	2
Checked & Approved By :		Um:	Each
Comment :	Est:B 03.02.28 Modify Step 1,2,3,4,21,23 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M5052H32S063	5052-H32 .063 Sheet
-----	--------------	---------------------

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR

Cut blanks: 3.00" x 1.520"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA296 and Dwg D3178

Identify as D3178-1

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- C'sink D3178-1 holes as per Dwg D3178

2- Deburr

Date: Tuesday, 11/22/2005 7:52:29 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 22409B

Part Number: D3178041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

10.0

MS20426AD34

RIVET

11.0

MS21059L3

Nut Plate

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D3178

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Job Completion



Date: Tuesday, 11/22/2005 7:52:38 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MOUNTING LUG ASSEMBLY
Job Number :	22409C		
Estimate Number :	10816		
P.O. Number :		Part Number :	D3175041
This Issue :	11/22/2005	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3175 REV. A
First Issue :	/ /	Project Number :	
Previous Run :	22409D	Drawing Revision :	A
Written By :		Material :	
Checked & Approved By :		Due Date :	11/29/2005
Comment :	Est:B 03.02.28 Modify Step 1,2,3,4,21,23 KJ/RF		

Qty: 2 **Um:** Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X02500	6061-T6 Bar 1.5" x 2.5"
-----	--------------------	-------------------------

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks: 2.5" x 1.5" x 2.2" (grain along 2.2")

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA293 and Dwg D3175

Deburr and Tumble

Identify as D3175-1

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Date: Tuesday, 11/22/2005 7:52:38 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG ASSEMBLY

Job Number: 22409C

Part Number: D3175041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT CHEMICAL CONVERSION COAT

8.0	D31751	Bracket
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9.0	D31753	Spacer
-----	--------	--------

10.0	AN37A	Bolt
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11.0	AN960JD10L	Washer
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12.0	MS21042L3	Nut
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13.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3175

14.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

15.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

16.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

17.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

18.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

